

Work Order ID 111132

January-09-14 12:31:36 PM

111132

Rev E 5/14/01/24

Page 1

~~PRELIMINARY ISSUE~~

Item ID: D4634-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Middle, Center Ceiling Panel Assembly

Stop

NS2

Start Date: 09/01/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

MP/MCS

Date: 14-01-001

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4634

PD2 PE1 24

Rev E

DAS

27

9-66

per 44N14-509

0.00

0.00

0.00

0.00

100

HandThermo

Memo

Hand Finishing Thermoforming

Pick Kit

①

SAO

14/01/23

110

110

Small Fab

Memo

Small Fab

1- Assemble as per Dwg D4634-043

2- Install led lights

3- Install Air valves

4-Install wiring harness

①

SAO

14/01/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111132

111132

Page 2

January-09-14 12:31:36 PM

Item ID: D4634-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Middle, Center Ceiling Panel Assembly
 Start Date: 09/01/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 24/01/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 DAS 27 9-89 14/1/23				1			inspected as per Dwg PEI
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							Thermforming MLJ
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ 14-01-23 MF 14-1-23

POSITIVE RECALL
 EFFECTIVE 14/01/22 AUTH
 RELEASED 5 DATE 14/01/24

POSITIVE RECALL
 EFFECTIVE 14/01/09 AUTH
 RELEASED DATE

inspected as per Dwg
 Rev E 14/1/23
 DAS 27 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

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Picklist Print

Tuesday, January 21, 2014 1:30:26 PM

Page 1

Work Order ID: 111132

Parent Item: D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
DL VERIFIED BY:JLM IPP Rev C Dwg Update 13/07/09 DL verf: DD
IPP Rev. D Dwg Update 13/12/23 DL IPP REV E Dwg Update 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4634-143 Middle, Center Ceiling Replacement Panel Assembly		Manufactured	No			100	Each	0.0000	1	1			
								BS111156		SAD		14/01/22	
D4646-1 Plenum Cap Assembly		Manufactured	No			100	Each	84.0000	2	2			
										SAD		14/01/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		84							
				103832		66							
				92968		6							
				95779		12				2			
D4652-1 Air Valve, 1.16 Id Disk Type		Manufactured	No			100	Each	203.0000	2	2			
										SAD		14/01/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		12							
				111316		12							
				ST099		191							
				111311		191		m111317		2			
D4728-053 Cabin Lights #2		Manufactured	No			100	Each	1.0000	1	1			
										SAD		14/01/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST121		1							
				93457		1				①			
PLT1.5M-M Tie Wrap		Purchased	No			100	Each	1,008.0000	3	3			
										SAD		14/01/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST389		1008							
				124363		8				3			
				m126551		1000							

Picklist Print

Tuesday, January 21, 2014 1:30:27 PM

Page 2

Work Order ID: 111132

Parent Item: D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

2351-20-27-C3C

Purchased

No

100

Each

80.0000

2

STUD

STUD 14/01/22

Location

Loc Qty

Loc Code

ST396

80

m126740

30

m127922

50

50-009-2

Purchased

No

100

Each

1.0000

2

Grommet

STUD 14/01/22

Location

Loc Qty

Loc Code

ST378

1

122594

1

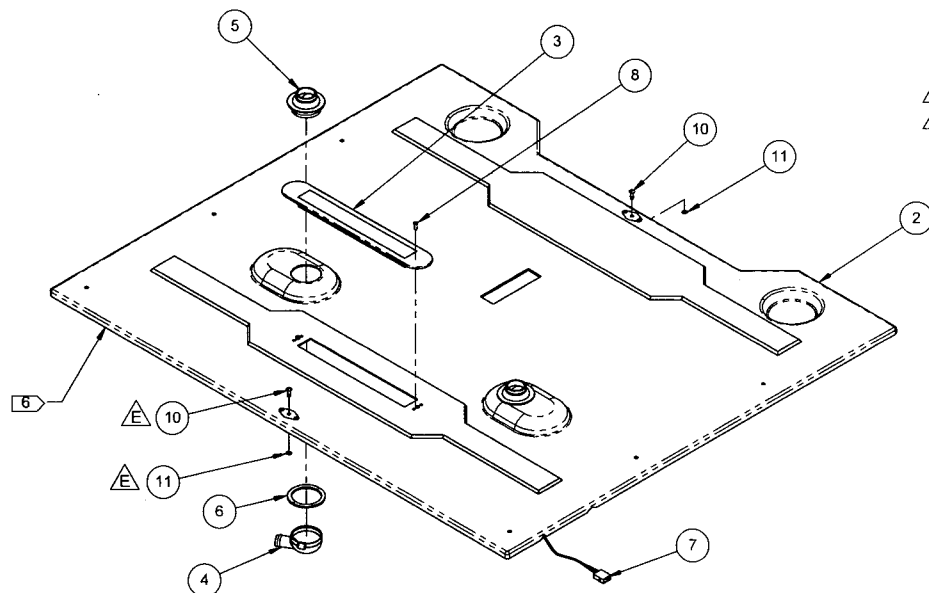
m 128022

2

Tuesday, January 21, 2014 1:30:27 PM

Shop Packet Print

Page 2



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

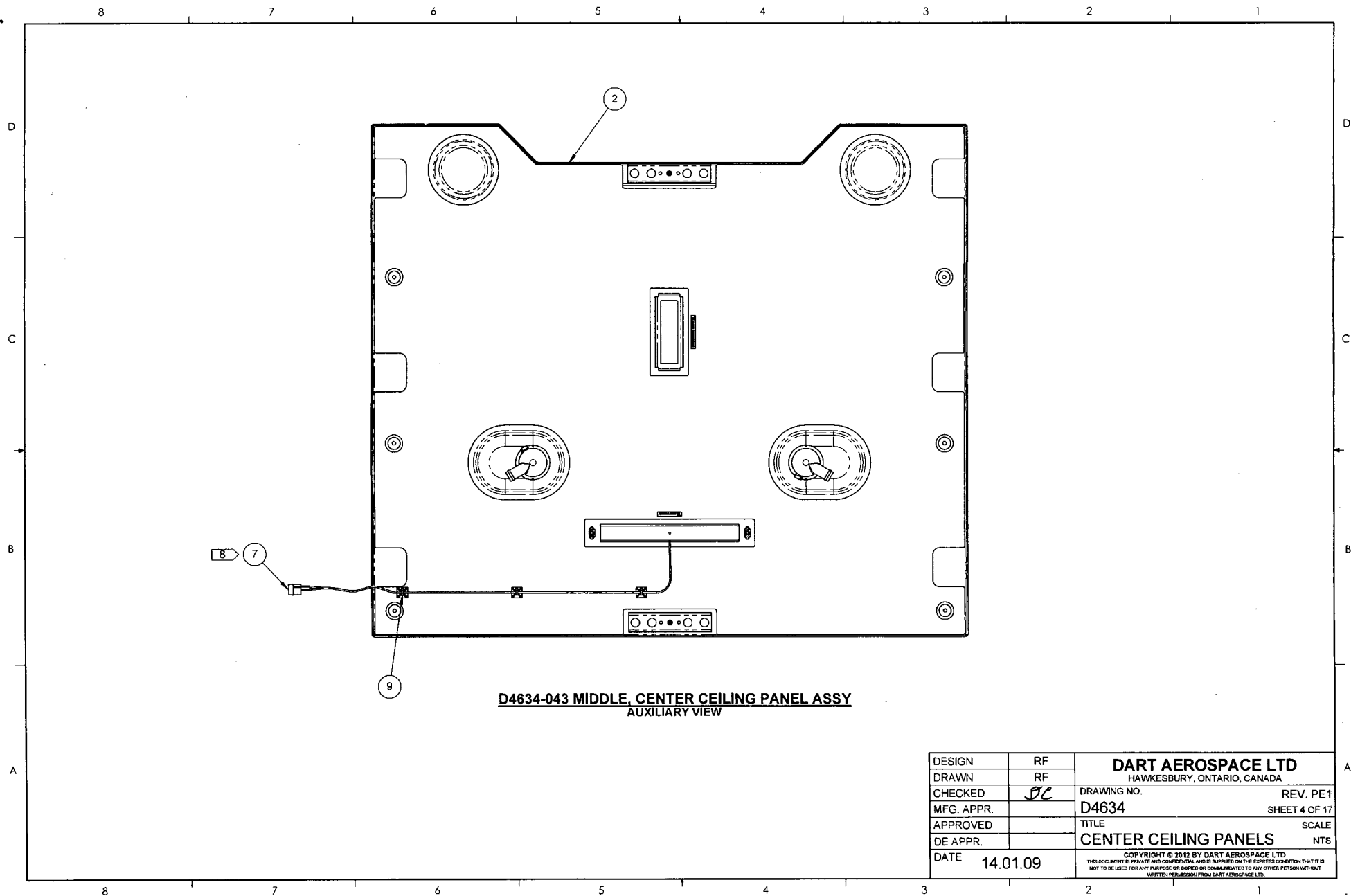
NOTES:

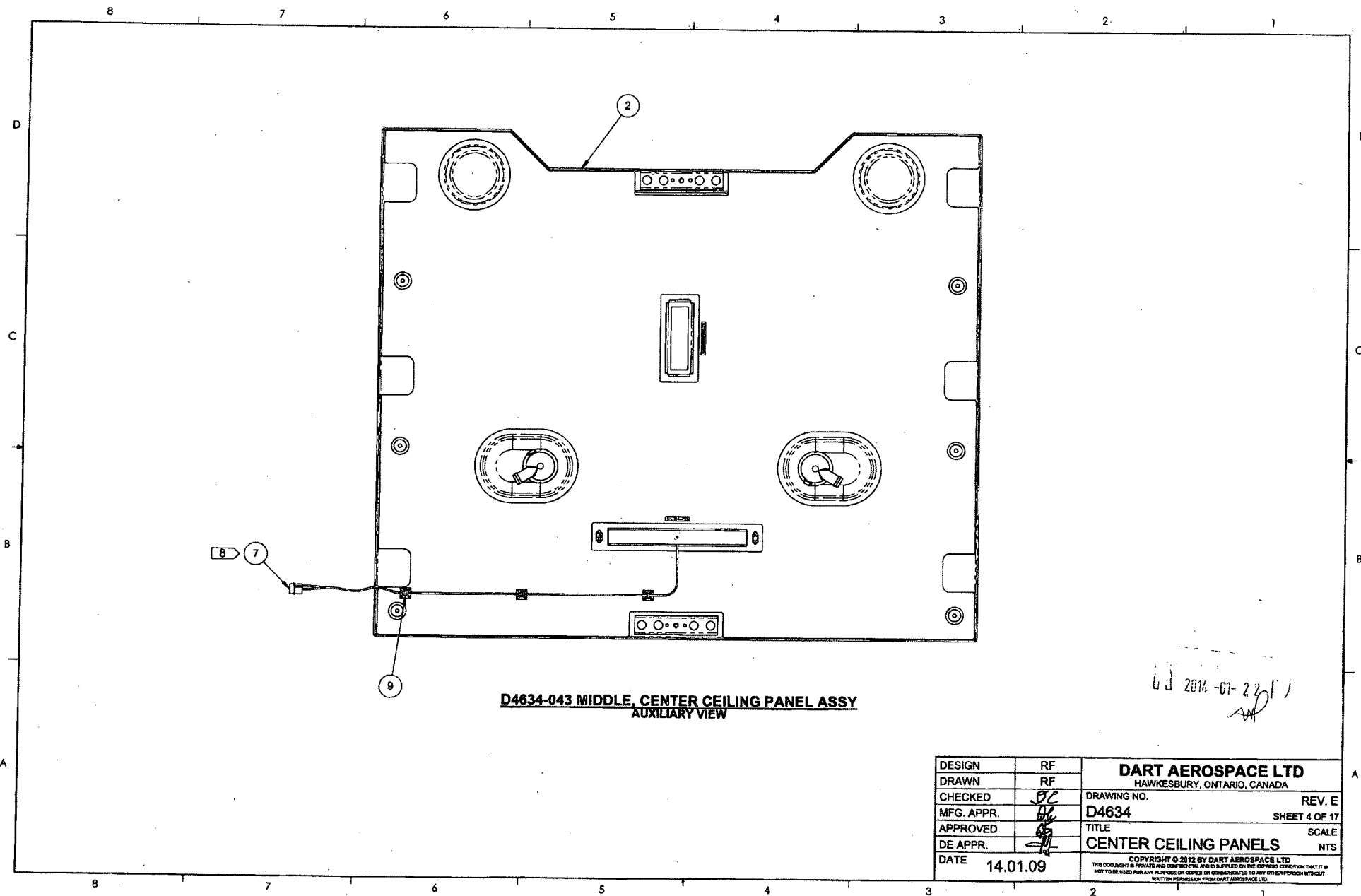
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.90 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143 ✓	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	2	D4646-1 ✓	PLENUM CAP ASSEMBLY
5	2	D4652-1 ✓	AIR VALVE
6	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
7	1	D4728-053 ✓	CABIN LIGHT #2 HARNESS ASSEMBLY
8	2	N/A (REF)	SCREW (PART OF D4728-053)
9	3	PLT1.5M-M ✓	TIE-WRAP (OR PLT1.5M-C)
10	2	2351-20-27-C3C ✓	STUD
11	2	50-009-2 ✓	GROMMET

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 3 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



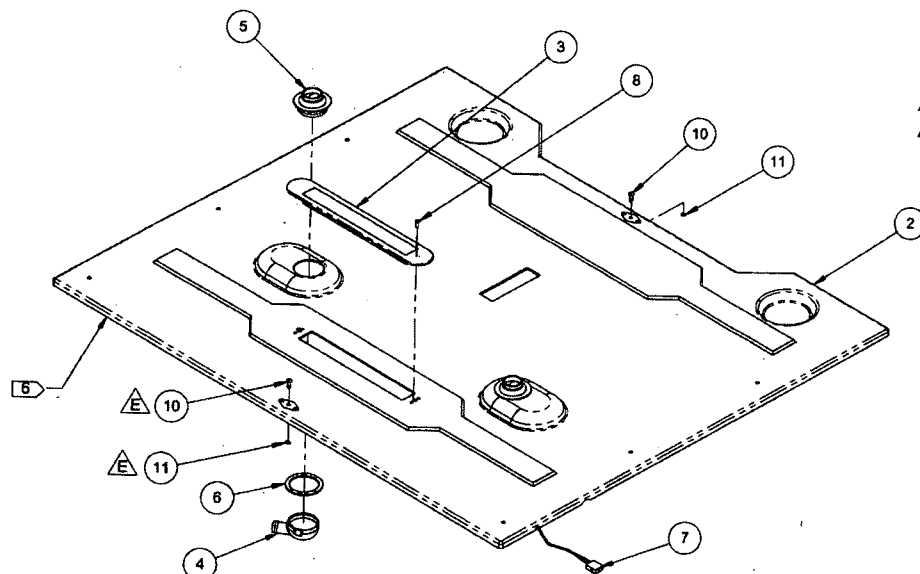




2014-01-23
AM

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4634	SHEET 4 OF 17
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CENTER CEILING PANELS	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	2	D4646-1	PLENUM CAP ASSEMBLY
5	2	D4652-1	AIR VALVE
E 6	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
7	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
8	2	N/A (REF)	SCREW (PART OF D4728-053)
E 9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
E 10	2	2351-20-27-C3C	STUD
E 11	2	50-009-2	GROMMET



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4634	SHEET 3 OF 17
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CENTER CEILING PANELS	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	